








Date: Tuesday, 11/29/2005 7:12:28 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services		Drawing Name : NUT PLATE ASSEMBLY	
Job Number : 25053			
Estimate Number : 11054			
P.O. Number : N/A		Part Number : D2873045	
This Issue : 11/29/2005 S.O. No. : N/A		Drawing Number : D2873 REVA	
Prsht Rev. : NC		Project Number : N/A	
First Issue : N/A Type : MACHINED PARTS		Drawing Revision : A	
Previous Run : N/A		Material : N/A	
Written By : <u>Est rev A 05/09/13 AP.</u>		Due Date : 12/18/2005 Qty: 20 Um: Each	
Checked & Approved By : <u>Same as above.</u>			
Comment : Created By Auto Work Order			
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0375X01000	6061T6 BAR	
			
Comment: Qty.: 0.2363 f(s)/Unit Total : 4.7250 f(s) 6061T6 BAR Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8) (M6061T6B0.375x01.000) Identify for D2873-5 Batch: <u>M18250</u>			
Tools: <u>3.6 05/12/17 20</u>			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut blanks: 1.000" x 0.375" x 2.700" long			
Tools: <u>3.6 05/12/17 20</u>			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev <u>A</u> Folio Rev <u>A</u>			
Tools: <u>3.6 05/12/17 20</u>			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

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Drawing Name: NUT PLATE ASSEMBLY

Job Number: 25053

Part Number: D2873045

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Tools:

S.G 05/12/18

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Tools:

S.D 05.12.18

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2- C'sink as per Dwg D2873

Tools:

FF 06-01-04 20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Tools:

20.01.04 20

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Tools:

FF 06-01-05 20

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

Tools:

20.01.05 20

10.0

MS20426AD46

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

4

MS20426AD4-6

Rivet

M 2930

Tools:

FF 06-01-05 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 06/01/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 25053

Part Number: D2873045

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

MS21075L5

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

2

MS21075L5

Nut Plate

M10136

Tools:

FF 06-01-05

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-045

Tools:

FF 06-01-05

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Tools:

FF 06-01-05

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 384

Tools:

06/01/06

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/10

20

06/01/09

Tools:

Job Completion



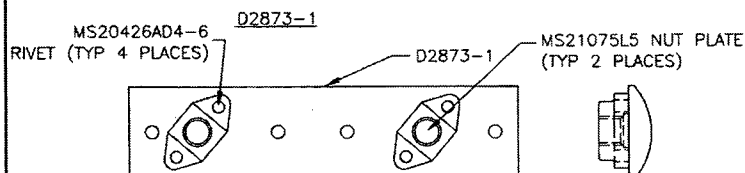
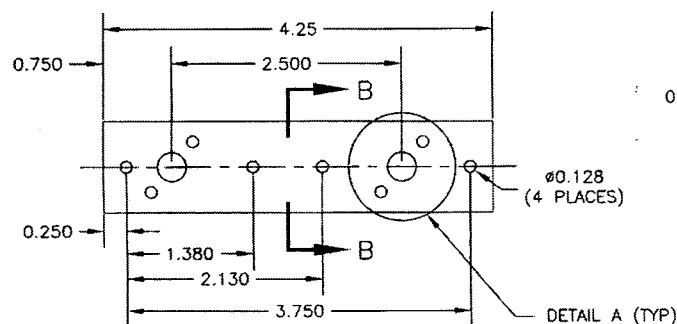
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

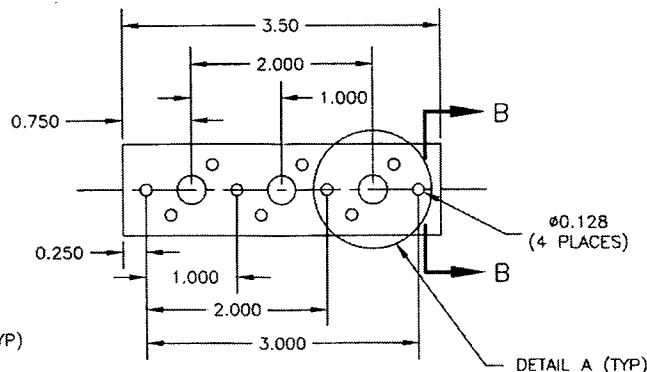
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

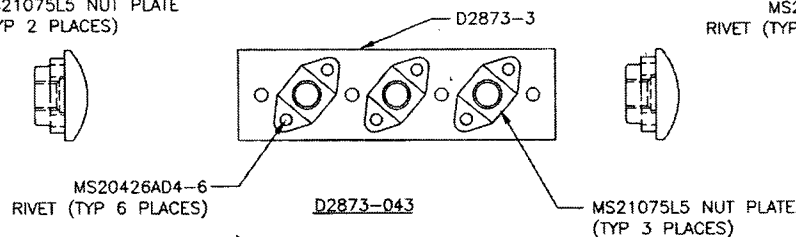
NOTE: Date & initial all entries.



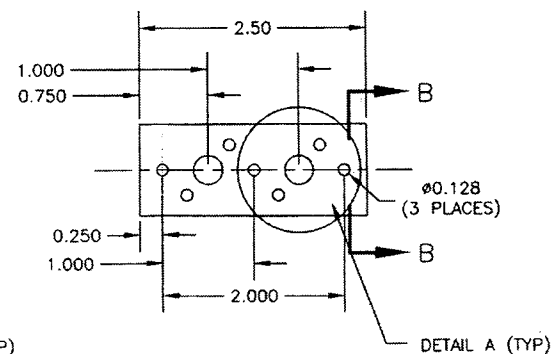
D2873-041



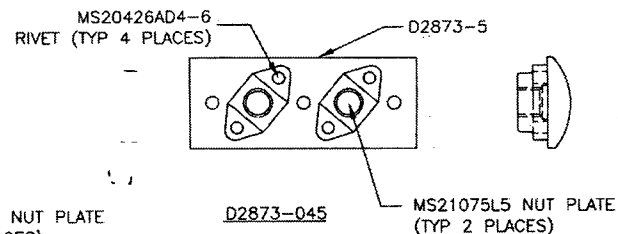
D2873-3



D2873-043



D2873-5



D2873-045

# D2873-1/-3/-5 RADIUS BLOCK

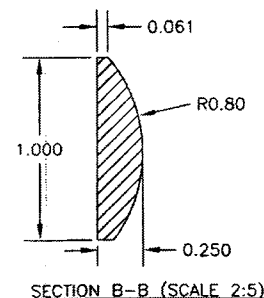
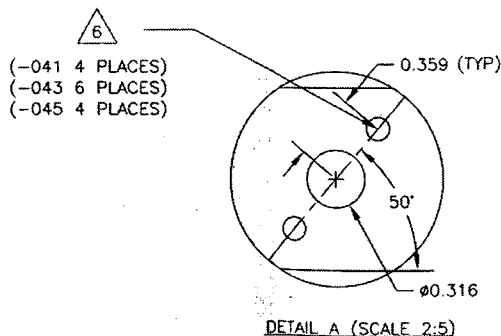
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

## D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

## D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED  
05.07.26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

3-

Q. 230 K.12.5

Prototype Approval:	N/A
Date:	N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD